

Work Order ID 151295***151295***

Page 1

Tuesday, September 20, 2016 1:41:02 PM

Item ID: D2011-101 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mirror 6"
Start Date: 9/20/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 10/4/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 20 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2011	Rev G								
100	PURCHASING	0.00							DAS 13 9-89
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 33718 Mirror P/N: 28663 supplier: B C INDUSTRIAL Material release note required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.04							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 SEP 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					
Root Cause		FAULT CATEGORY																							
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																			
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																			
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																			
Equip/Tooling ☐		Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																			
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																			
Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																			
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LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																			
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																			
Past Expiry Date ☐		Manufacturing Process ☐	OTHER :																						
Misidentified ☐		Past Due ☐																							

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130		0.00							
130	Small Fab								
Small Fab	Memo	0.08							
Small Fab	1- Wrap mirror with plastic wrap								
	2- Discard Hardware & Install new hardware loosely								
	3- Crimp stud as per Dwg D2011								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.04							
Quality Control	4- Test assembly to 50lbs pull test after 24 hours								
150	Identify as per dwg & Stock Location: <u>5324</u>	0.00							
150									
Packaging	Memo	0.02							
Packaging									

DAS 36 9-89
DAS 38 9-89
SEP 29 2016
DAS 6 9-89
SEP 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
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Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____ _____ _____			
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

SEP 30 2016

DAS
21
9-89

SEP 30 2016

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, September 20, 2016 1:41:05 PM

Page 1

Work Order ID: 151295

151295

Parent Item: D2011-101

D2011-101

Parent Item Name: Mirror 6"

Start Date: 9/20/2016

Required Date: 10/4/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: J04.09.15 Added Steps 5-7 KJ/JLM IPP:
K05.12.15 chg black sika flex for white EC IPP L 08.11.06 new
drawing EC verify: DD IPP: M 08.12.19 Added step 3 KJ Verified
by: LL IPP rev N 10.01.13 added wrap per ncr09-118 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149D0416J		Purchased	No			110	Each	3,763.000	1	12			
NAS1149D0416.J									**				
WASHER													

16/09/28 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	81	
m131511	81	
ST260a	1976	
m131511	1976	
ST264	1706	
m131511	1706	

12

CHM-10601

Purchased

No

130

Each

0.0000

1

12

CHM-10601

Mirror 6"

D2829

Manufactured

No

130

Each

22.0000

1

12

D2829

Threaded Stud

12 x 5/16-9-26
16/09/28 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	22	
122346	1	
146644	21	

12

DQA: _____ Date: _____



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Description Work Order Deviation		Disposition			
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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
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Picklist Print

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Work Order ID: 151295

151295

Parent Item: D2011-101

D2011-101

Parent Item Name: Mirror 6"

Start Date: 9/20/2016

Required Date: 10/4/2016

Start Qty: 12.00

Required Qty: 12.00

D3014-1

Manufactured No

130

Each

126.0000

1

12

D3014-1

Lock Nut

16/09/2016
DAS
8:36
8:39

Location

Loc Qty

Loc Code

ST015

126

122272

126

12

DQA: _____ Date: _____



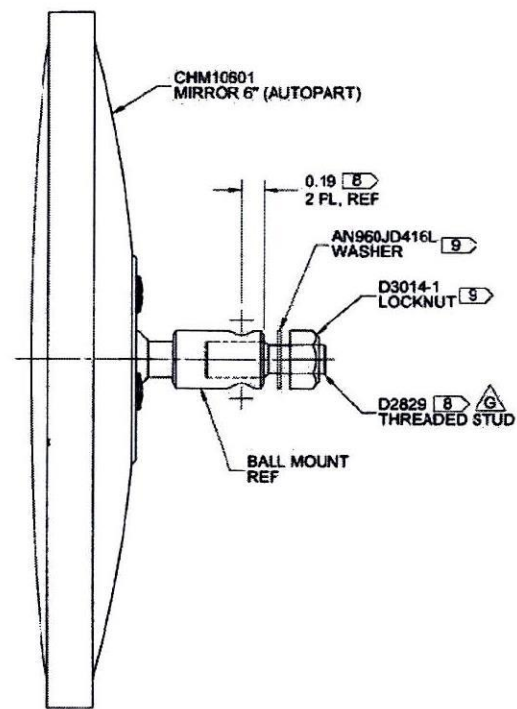
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

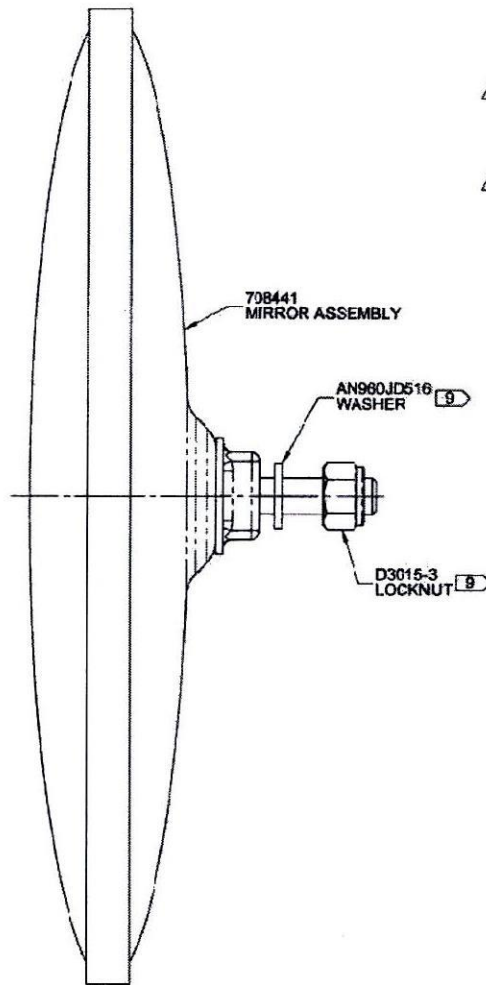
Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

8 7 6 5 4 3 2 1



D2011-101 MIRROR ASSEMBLY 6"



D2011-103 MIRROR ASSEMBLY 8"

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2011-101 = 0.6 lbs APPROX. ; D2011-103 = 1.0 lbs APPROX.
- 8) D2829 INSTALLATION PROCEDURE:
 - APPLY LOCKTITE 262 TO $\phi 5/16$ END OF D2829
 - THREAD BY HAND INTO BALL MOUNT UNTIL ENTIRE $\phi 5/16$ END OF D2829 IS WITHIN BALL MOUNT
 - CRIMP BALL MOUNT ON TWO OPPOSING SIDES, 0.19 FROM END AS ILLUSTRATED USING TOOL DT8317
 - CRIMP TO DEPTH OF 0.040 ± 0.010 USING R0.125
- 9) INSTALL LOOSE

ITEM	QTY -101	QTY -103	P/N	DESCRIPTION
1	X		D2011-101	MIRROR ASSEMBLY 6"
2		X	D2011-103	MIRROR ASSEMBLY 8"
3	1		D2829	THREADED STUD
4	1		D3014-1	LOCKNUT
5		1	D3015-3	LOCKNUT
6	1		CHM10801	MIRROR 6" (AUTOPART)
7		1	708441	MIRROR 8" (VELVAC)
8	1		AN960JD416L	WASHER
9		1	AN960JD516	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 151295 MJS
100920
RELEASED
06-10-29

G	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT. MIRROR 6" (AUTOPART) AND CHM10801 WERE MIRROR 6" (GROTE) AND P/N 28043 (ZIN D3-1); ADDED D2829 (ZIN D3-1 AND ZIN CS-1); REMOVED DRILLING NOTE, VIEW A-A AND SIKAFLEX APPLICATION NOTE. REASON: GROTE PRODUCT IS DISCONTINUED	MB	06.10.06
F	ADD HOLES FOR SEALANT ON -101	CP	04.09.10
E	NEW 8" MIRROR	CP	01.05.08
D	NEW 6" MIRROR, ADD NUT, REMOVED STUD	CP	01.04.23
C	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	RF	99.06.01
B	SIKAFLEX 241 ADDED	JB	98.04.09
A	DWG NO. WAS DSP 1011, ADDED -103	JB	90.06.15
-	NEW ISSUE	JB	90.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.06		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D2011			
TITLE MIRROR ASSEMBLY			
REV. G SHEET 1 OF 1 SCALE NTS			
COPYRIGHT © 1980 BY DART AEROSPACE LTD			

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OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33718**

Purchase Order Date 9/21/2016

PO Print Date 9/22/2016

Page Number 1 of 2

Order From :
B C INDUSTRIAL
14 OLD FOREST
KIRKLAND, QUEBEC H9J 2Z8

VC-BCI001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name
Vendor Phone 514-585-8907

Ship To Contact
Ship To Phone
Ship Via: FedEx Economy collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	71400-40	#6712 3" ROLLER	9/27/2016 Yes 9/27/2016		20.00 Each	\$3.65	\$73.00

Line Total: \$73.00

Deliver To: GARY

2	28663	Mirror 6"	9/27/2016 Yes 9/27/2016	FN	12.00 Each	\$18.70	\$224.40
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AS PER DWG D2011 REV. G
B151295

Line Total: \$224.40

Sp/6 9-26

PO Instructions: Procurement Quality Clauses
A000 QUALITY CLAUSES NOT REQUIRED

Note:

9/22/2016

Sept 22 2016

Packing Slip

PS160922DA

Livrer a/Ship to:

Dart Aerospace Ltd
1270 Aberdeen
Hawksbury, Ont
K6A 1K7

Votre PO# 33718

Description	Livrer/Ship	B/O
1. paint roller 6712	20	0
2. mirror 28663	12	0
3.		
4.		

Sp/6-9-26

BC Industrial.... 14 Old Forest....Kirkland, Quebec.. H9J2Z8
Phone 514-585-8907 bcpc1@videotron.ca

BC Industrial..... 14 Old Forest....Kirkland....Quebec....H9J-2Z8....Canada
Phone 514-585-8907 Email bcpci@videotron.ca

FACTURE/INVOICE
Ref Notre PS# PS160922DA

INV160922DA **Sept 22 2016**
Votre PO# 33718

Vendu a

Dart Aerospace Ltd
1270 Aberdeen
Hawksbury, Ont
K6A 1K7

Description	Quan	Prix	Total
1. paint roller 6712	20	3.65	73.00
2. <u>mirror 28663</u>	<u>12</u>	18.70	<u>224.40</u>
3.			
4.			

Sp/6-9-26.

297.40

HST 38.66

TOTAL 336.06

#TPS/GST-14264062
#TVQ/PST-1021696907

Terms 2%10 Net 30

BC Industrial..... 14 Old Forest....Kirkland....Quebec....H9J-2Z8....Canada
Phone 514-585-8907 Email bcpc1@videotron.ca

Certificate of Compliance

Sept 22 2016

Dart Aerospace
1270 Aberdeen
Hawkesbury, Quebec
K6A-1K7

ATT: Chantal Lavoie

This is to confirm that the parts delivered on our PS 1600922DA

Mirror 28663

conforms to the specifications outlined on your purchase
order 33718

Thank you

A handwritten signature in blue ink, appearing to be "Bryan Cameron", with a long horizontal line extending to the right.

Bryan Cameron

#TPS/GST-142640622
#TVQ/PST-1021696907

Terms 2%10 Net 30